

Date: Thursday, 2/23/2006 10:24:16 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FOLDING STEP WELDMENT LH
Job Number	: 25926		
Estimate Number	: 10463		
P.O. Number	: N/A	Part Number	: D3388041
This Issue	: 2/23/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3388 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25873	Drawing Revision	: A
	Type : LARGE FAB ASSY	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 3/28/2006
Checked & Approved By	: JF 06.02.23	Qty:	3 Um: Each
Comment	: Est. B 05.06.10 Added Step 11 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
 D2622-120C extrusion 8
 Batch: 324092 = (2) 324563 = (1)

JE 06.03.21

3

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
 1-Cut D2622-120C extrusion 85.15" long as per Dwg D3388
 2-Deburr and bevel ends for welding

JE 06.03.21

3

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
 206 Step Endplate
 Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	324402

JE 06.03.21

3

4.0	D33871	Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Arm
 Pick:

Qty	Part Number	Description	Batch
2	D3387-1	Arm	324119 = (2)

326161 = (2)

325933 = (2)

JE 06.03.22

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld arms and end caps as per Dwg D3388.

Inspect for foreign objects as per QSI 024. Dwg Rev: A

Grind end cap welds flush

Handwritten: 06.03.22 2
06.03.24 1

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: DL 06/04/01 (3)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten: DL 06/04/12 (3)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3388 and QSI 005 4.4

Handwritten: FC 06 04 13 (3)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect Powder Coat and Wing Walk

Handwritten: DL 06/04/13 (3)

10.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Spacer

Pick:

Qty	Part Number	Description
1	D2808	Spacer

Batch

Handwritten: 1325248

Handwritten: SAN 06:04:22

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press spacer into D3387-1 arm as per Dwg D3387

Handwritten: SAN 06:04:22 (7)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



206.04.23

(3)

Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SAD

06:05:10

(3)

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 0605/11

(3)

Job Completion



u 0605/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

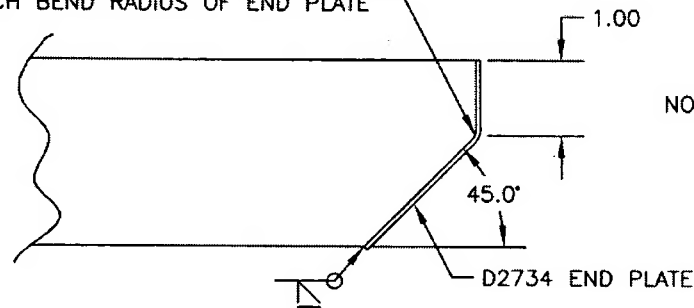
DART

RELEASED

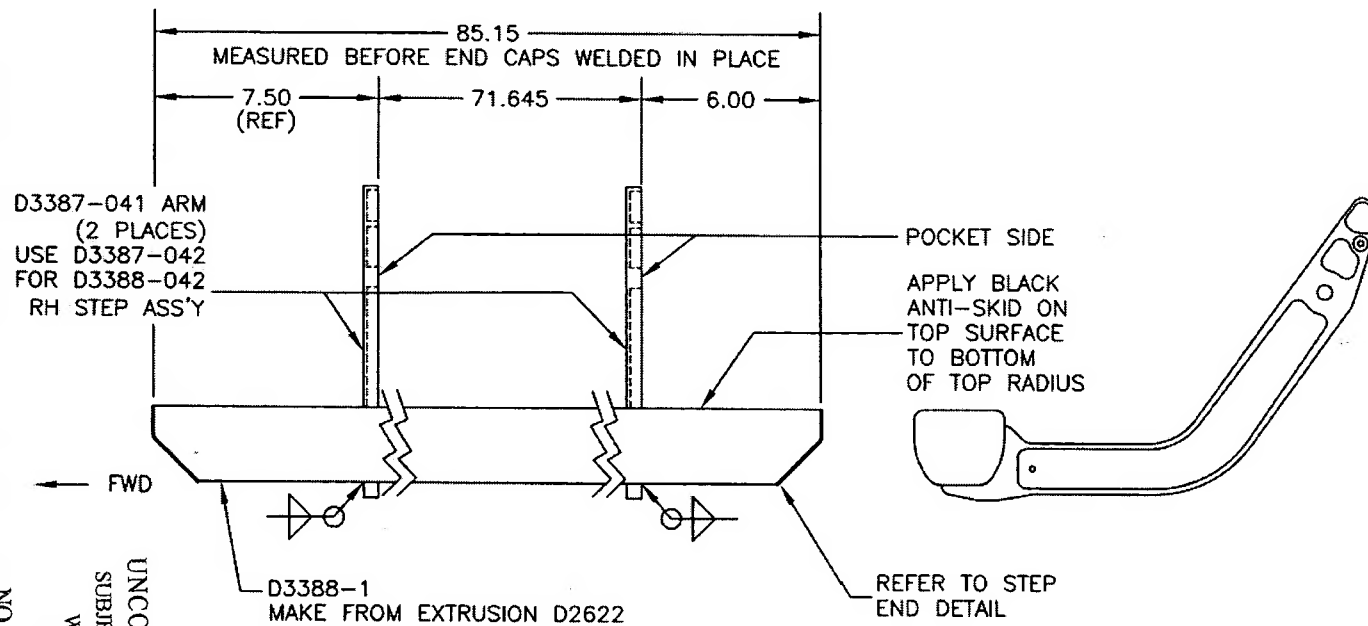
05-03-11

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE



D3388-041 LH STEP ASSEMBLY (SHOWN)
D3388-042 RH STEP ASSEMBLY (OPPOSITE)

- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2) WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. A
CP	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
CP	CP	D3388	
DATE	TITLE	SCALE	
05.01.20	STEP WELDMENT	NTS	
A	05.01.20	NEW ISSUE	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-03-26	6.2	Inspect alocine QC3	[Signature]	06-04-03	3	[Signature]	[Signature]	
	6.23	weld 2nd end cap AS per Dwg D3388 and grind flush inspect for defects		06-04-04	3			
	6.24	Inspect QC 5/9		06-04-06	3			
	6.25	touch-up endcap with alocine AS NECESSARY AS per QSI 005 4.1		06-04-08	3			
		change made						
	6.1	QC 5/9 Inspect work	[Signature]	06-03-26	3	[Signature]	[Signature]	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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